

Date: Thursday, 29/05/2008 11:04:37 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	39556		
Estimate Number :	11964		
P.O. Number :		Part Number :	D2052
This Issue :	29/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2052 REVD
First Issue :	/ /	Project Number :	N/A
Previous Run :	36617	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JUD 08.5.29	Due Date :	05/06/2008
Comment :	Est C 01.08.21 Added Finishing SM (Issue this IPP with part number D2053) Est Rev:D now water jet 07-10-25 DD Est Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC		
		Qty:	40
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S090	5052-H32 .090 Sheet
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Comment: Qty.: 0.1355 sf(s)/Unit Total : 5.4180 sf(s)
 Material: 5052-H32, 0.090" Thick
 (M5052H3S.090)
 Batch: 100782 IB 8-6-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2052
 Dwg Rev: D IB 8-6-2
 Prog Rev: D
 ****grain direction along 3.878" ****
 2-Deburr if necessary

(40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 0806/03 (40) counts

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:04:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39556

Part Number: D2052

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2052 using CNC Brake

SB 08/06/09

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/09 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005

FL 08/06/09 (40)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
320 OF
12:00

M-1 08/06/09

(40X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/06/09 (40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 14

AS 08/06/09 (40)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



W 08.06.10

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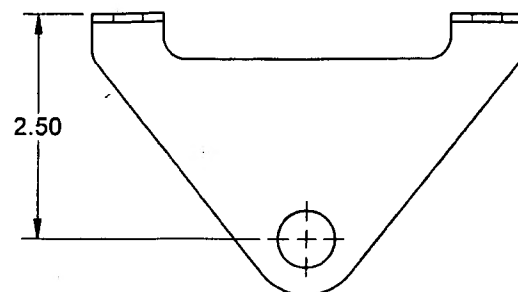
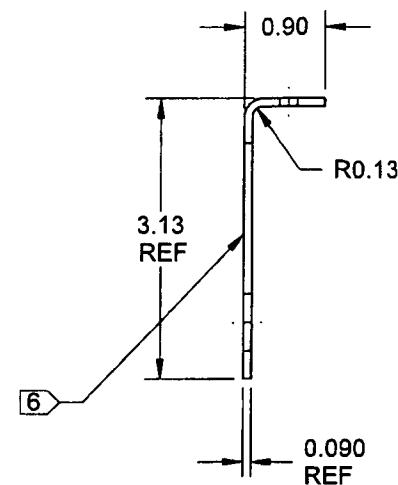
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

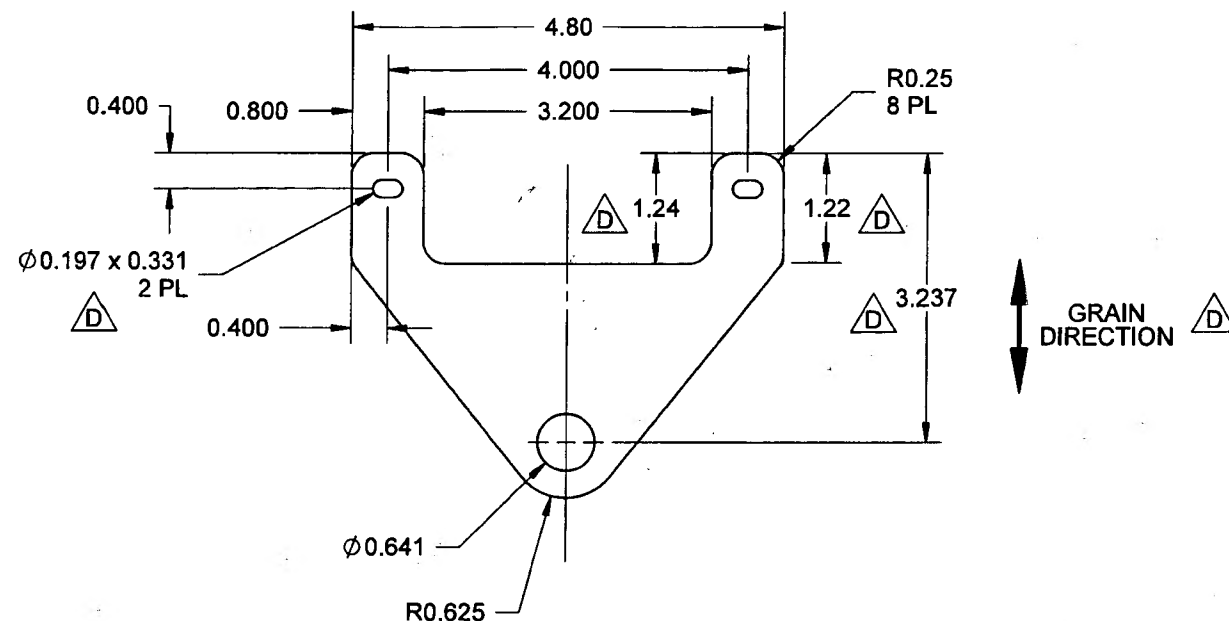
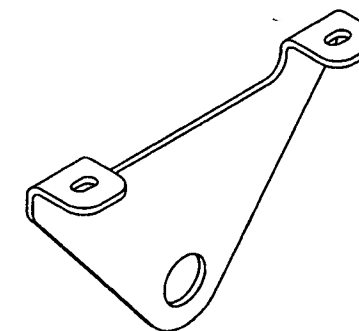
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2052 BRACKET



D2052F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31556

RELEASED
08-05-13/14

D	WIDEN SLOT (ZN B7-1); UPDATE FLAT PATTERN DIMENSIONS (ZN B5-1, B6-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A8-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)	PH	08.04.28
C	ADD FLAT PATTERN	RF	99.04.30
B	ADD SLOT TO FOOT	BW	97.02.21
A	NEW ISSUE	BW	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PL		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	TH	D2052	SHEET 1 OF 1
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	BRACKET	NTS
DATE	08.04.28	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

